

D3173-041 ?

DART AEROSPACE LTD	Work Order:	20380
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	3
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Note: K10017 Kits to be made in multiples of 4. (1) K10017 Kit consists of (2) D3175-041 and (2) D3178-041.	HA	04.02.16	3
2	MV	Cut blanks: 3.00" x 1.520" Material: 5052-H32/H34 sheet (QQ-A-250/8) 0.063" thick (M5052H32S.063) (Cut 1 stack of 8 per (4) K10017) Identify as D3178-1 Batch: _____			
3	MV	Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2") Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) (M6061T6B1.500x02.500) (Cut 16 blanks per (4) K10017) Identify as D3175-1 Batch: _____ (Note: (2) D3175-1 are required per D3175-041 assembly)			
4	MV	Cut blanks: 2.125" x 1.250" Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) (Cut 8 blanks per (4) K10017) Identify as D3175-3 Batch: _____			
5	MV	Machine D3178-1 as per Folio FA296 and Dwg D3178			
6	QC2	Inspect parts as they come off the CNC machine			
7	QC8	Second inspection			
8	MV	Machine D3175-1 as per Folio FA293 and Dwg D3175			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr and Tumble			
11	QC8	Second inspection			
12	MV	Machine D3175-3 as per Folio FA294 and Dwg D3175			
13	QC2	Inspect parts as they come off the CNC machine			
14	MV	Deburr and Tumble			
15	QC8	Second inspection			
16	GA	C'sink D3178-1 holes as per Dwg D3178			
17	GA	Deburr stack of D3178-1			
18	QC5	Inspect C'sink			
19	FP	Chemical Conversion Coat D3178-1, D3175-1 & D3175-3 per QSI 005 4.1			

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

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Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
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		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																
20	QC3	Inspect Conversion Coat																			
21	GA	Assemble D3178-041 as per Dwg D3178 Pick: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>16</td><td>MS20426AD3-4</td><td>Rivet</td><td>_____</td></tr><tr><td>8</td><td>MS21059L3</td><td>Nut Plate</td><td>_____</td></tr></table> Identify as D3178-041	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	16	MS20426AD3-4	Rivet	_____	8	MS21059L3	Nut Plate	_____							
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																		
16	MS20426AD3-4	Rivet	_____																		
8	MS21059L3	Nut Plate	_____																		
22	QC5	Inspect D3178-041 Assembly																			
23	GA	Assemble D3175-041 as per Dwg D3175 Pick: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>4</td><td>AN3-7A</td><td>Bolt</td><td>_____</td></tr><tr><td>8</td><td>AN960JD10L</td><td>Washer</td><td>_____</td></tr><tr><td>4</td><td>MS21042L3</td><td>Nut (or -3)</td><td>_____</td></tr></table> Identify as D3175-041	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	4	AN3-7A	Bolt	_____	8	AN960JD10L	Washer	_____	4	MS21042L3	Nut (or -3)	_____			
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																		
4	AN3-7A	Bolt	_____																		
8	AN960JD10L	Washer	_____																		
4	MS21042L3	Nut (or -3)	_____																		
24	QC5	Inspect D3175-041 Assembly																			
25	FP	Powder Coat D3175-041 Only Gloss White (Ref: 4.3.5.1) per QSI 005 4.3																			
26	QC3	Inspect Powder Coat																			
27	PK	Identify and Stock as K10017. Note: (1) Kit consists of (2) D3175-041 and (2) D3178-041. <table><tr><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Qty</u></td></tr><tr><td>D3175-041</td><td>Mounting Lug</td><td>_____</td></tr><tr><td>D3178-041</td><td>Nut Plate</td><td>_____</td></tr></table>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>	D3175-041	Mounting Lug	_____	D3178-041	Nut Plate	_____										
<u>Part Number</u>	<u>Description</u>	<u>Qty</u>																			
D3175-041	Mounting Lug	_____																			
D3178-041	Nut Plate	_____																			
28	AC	Parts to stock and Prorate cost to parts per Step 27. Cost / part <u>0</u>		5/04/02-17																	
29	DC	Close W/O Inspect Level 21																			

Rev	Date	Change	Revised By	Approved
A	03.01.28	New issue	KJ/RF	
B	03.02.28	Modify Step 1,2,3,4,21,23	KJ/RF <i>RF</i>	<i>[Signature]</i>

RELEASED
03.02.04 *RF*

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 16, 2004
01:36 pm

Work Order No : 0020380
Project Name : *K10017
Project For : WK40942
Work Order Type : Main
Main WO Number :
House Part Number : *K10017
Description : Mtg Lug/Nut Plate Kit
Manufactured : Yes
Amount Req'd : 3
Amount Done : 0
Start Date : 02-16-04
Est Finish Date : 02-26-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00